

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
690 Walnut Ave. St. 150  
Vallejo, CA 94592-1133  
(707) 649-5453  
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-009463**Date Inspected:** 14-May-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Jun**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower&OBG**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Utekar Shrikant was present during the times noted above for observations relative to the work being performed.

BAY#10

**Magnetic Particle Inspection**

This Q.A Inspector performed Magnetic Particle testing of approximately 15% of the area previously tested and accepted by ZPMC Quality control personnel. This QA Inspector generated a (M.T) report for this date. The members are identified as the Inside corner weld between Skin A and E of South Tower Lift 2 at 53m Double Diaphragm the welds Designation are as follows.

SSD1-TL5B/L-1B at Double Diaphragm 53

**Visual Inspection**

This Q.A Inspector performed approximately 100% Visual Inspection of the area previously tested and accepted by ZPMC Quality control personnel. The members are identified as the Inside corner weld between Skin A and E of South Tower Lift 2 at 53m Double Diaphragm the welds Designation are as follows.

SSD1-TL5B/L-1B at Double Diaphragm 53

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## WELDING INSPECTION REPORT

( Continued Page 2 of 3 )

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This QA Inspector randomly observed the following work in progress

BAY#11

SMAW welding process of weld joint 18 located on PCMK ND1-A468-38M-1. Welder is identified as 053916 ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113

SMAW welding process of weld joint 84B located on PCMK EST L3-4BK. Welder is identified as 040675 ZPMC QC is identified as Li Jun. The welding variables recorded by QC appeared to comply with the WPS-B-T-2214

FCAW welding process of weld joint 4A located on PCMK WSD-TL6B/L. Welder is identified as 044558 ZPMC QC is identified as Zhang Ji. The welding variables recorded by QC appeared to comply with the WPS-B-T-2221-C-U2B-S-2

FCAW welding process of weld joint 17 located on PCMK WSD1-FASA3-2C/E. Welder is identified as 069043 ZPMC QC is identified as Lue Bin. The welding variables recorded by QC appeared to comply with the WPS-B-T-4332.

BAY#10

FCAW welding process of weld joint 61A located on PCMK NSD1-FASA3-1E/E. Welder is identified as 040533 ZPMC QC is identified as Su Zhen Yong. The welding variables recorded by QC appeared to comply with the WPS-B-T-2332-TC -P5-F

FCAW welding process of weld joint 3 located on PCMK NSD1-FASA3-3BC. Welder is identified as 050041 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113-TC-P5-F

FCAW welding process of weld joint 2 located on PCMK NSD1-FASA3-3BC. Welder is identified as 057266 ZPMC QC is identified as Yuan Hui Gang. The welding variables recorded by QC appeared to comply with the WPS-B-T-2113-TC-P5-F

Unless otherwise noted, all work observed on this dated appeared to generally comply with applicable contract documents.

**Summary of Conversations:**

No relevant conversation

**Comments**

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge Sinevod 134-8257-0045, who represents the Office of Structural Materials

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## WELDING INSPECTION REPORT

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for your project.

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**Inspected By:** Utekar,Shrikant

Quality Assurance Inspector

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**Reviewed By:** Dawson,Paul

QA Reviewer